

Work Order ID 86330

\*86330\*

Page 1

June-27-12 1:26:35 PM

Item ID: D2600-3-BENT

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Extrusion Bent

Start Date: 27/06/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/27 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2600	Rev E								
D2750	F								
100	BENDING MACHINE - SKIDTUBES	0.00							
*100*									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Pick qty 1 D2600-3-120 extrusion								
	1-Deburr one end of extrusion								
	2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635								
	3- cut fwd end of tube as per dwg D2750								
	4- cut aft end of tube as per dwg D2750								
110	QC5- Inspect part completeness to step on W/O	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

CF 12-6-28

DP

12-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86330

**\*86330\***

Page 2

Item ID: D2600-3-BENT

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Extrusion Bent

Start Date: 27/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <b>46</b>	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

*[Handwritten signature]*

*12-6-28*

*(20)*

*12/6/28*

*12-06-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 86330

\*86330\*

Parent Item: D2600-3-BENT

\*D2600-3-BENT\*

Parent Item Name: Extrusion Bent

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120		Manufactured	No			100	Each	102.0000	1	20			

\*D2600-3-120\*

Extrusion Round 3" 350

\*\*

### Location

HALL

80053

82078

### Loc Qty

102

63

39

### Loc Code

20

12628

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## D2600-X-XXX EXTRUSION

### NOTES:



- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI  
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).  
D2600-1 EXTRUSION MANUFACTURED FROM:  
- CARADON INDALEX DIE # MH-18870  
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).  
D2600-3 EXTRUSION MANUFACTURED FROM:  
- CARADON INDALEX DIE # MH-18859  
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).  
D2600-5 EXTRUSION MANUFACTURED FROM:  
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).  
D2600-7 EXTRUSION MANUFACTURED FROM:  
- CARADON INDALEX DIE # MS-18872

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WORK ORDER

NO. 86330 ML5

12/06/27

RELEASED  
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (08-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3. UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>4</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>Q</u>		
CHECKED	<u>AJS</u>	DRAWING NO.	REV. E
MFG. APPR.	<u>E</u>	D2600	SHEET 1 OF 3
APPROVED	<u>#</u>	TITLE	SCALE
DE APPR.	<u>#</u>	EXTRUSION	NTS
DATE	11.10.18	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

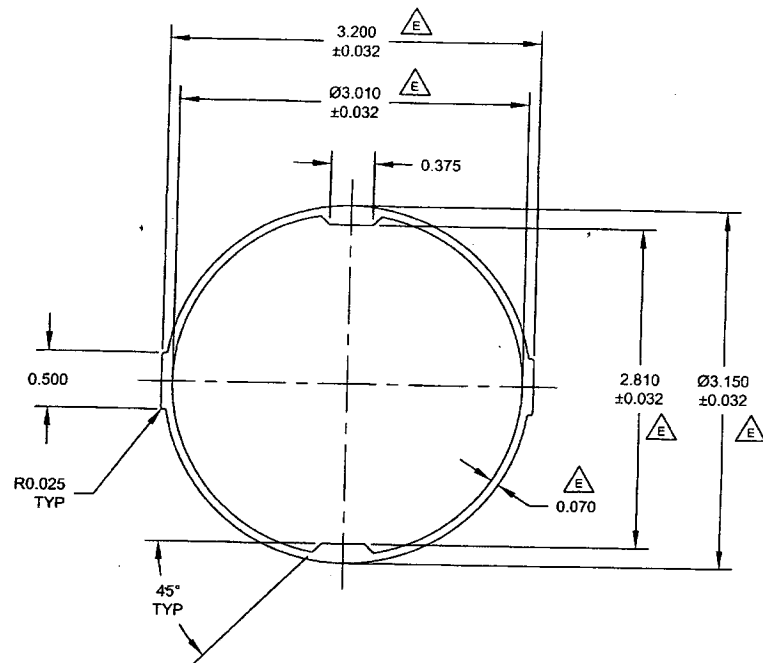
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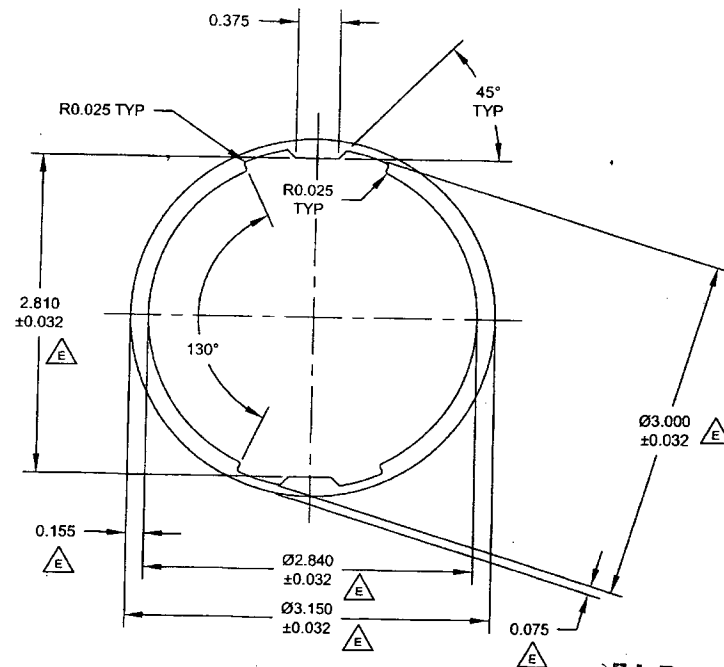
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86330



D2600-1 EXTRUSION



D2600-3 EXTRUSION

RELEASED  
2012-01-10

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. E
MFG. APPR.		D2600 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		EXTRUSION NTS
DATE	11.10.18	

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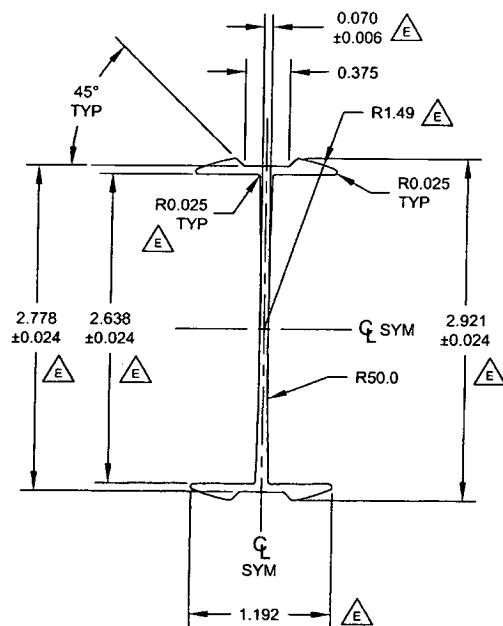
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

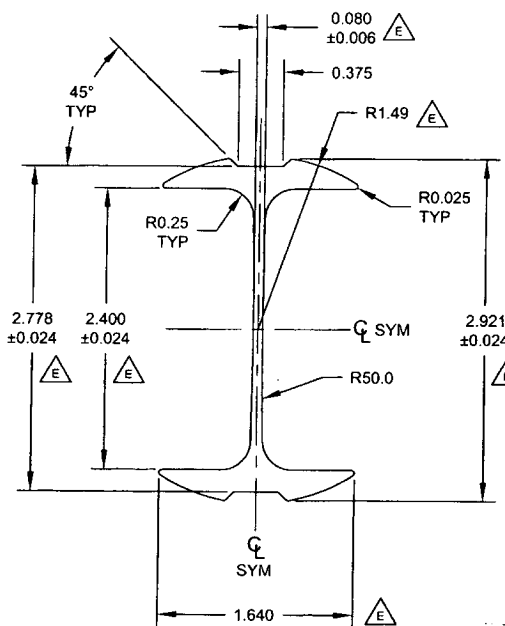
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**NOTE:** Date & initial all entries



D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED  
2012-01-11  
JWD

DESIGN	<i>4</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>EL</i>	D2600	SHEET 3 OF 3
APPROVED	<i>EL</i>	TITLE	SCALE
DE APPR.	<i>EL</i>	EXTRUSION	NTS
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**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 86330 MLJ

12/06/27

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDIAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NOR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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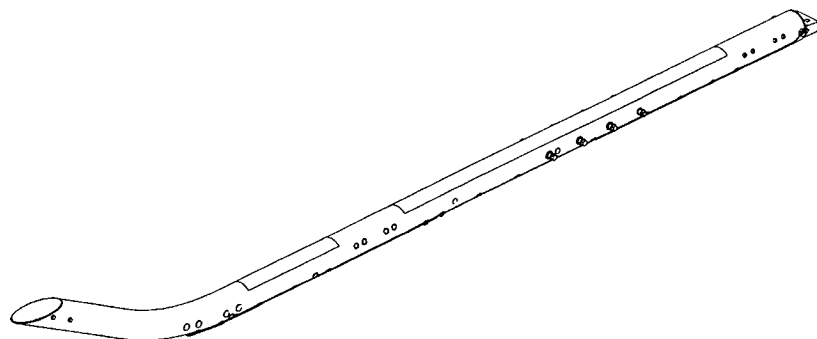
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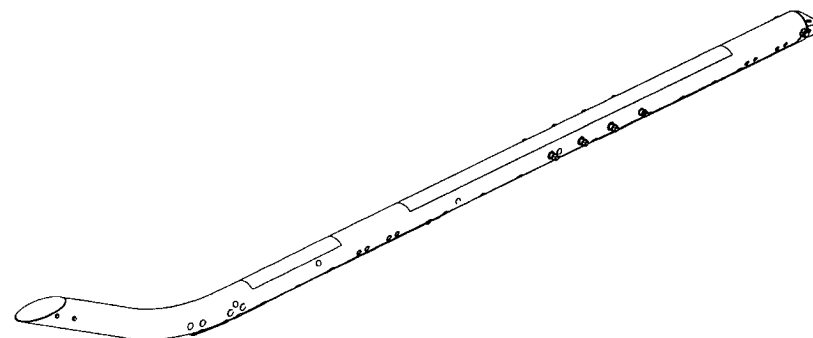
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8633d



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08-02-16

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

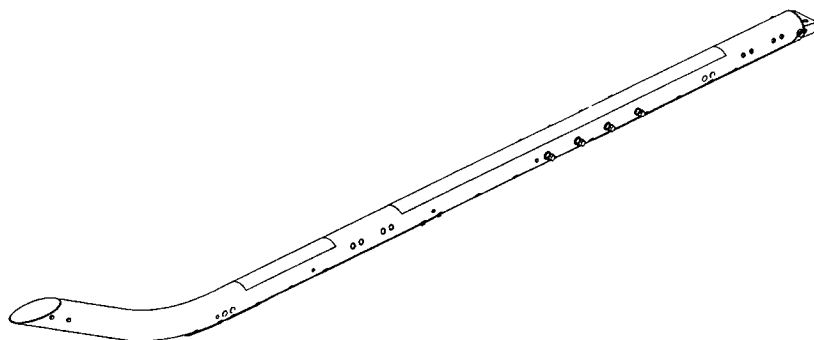
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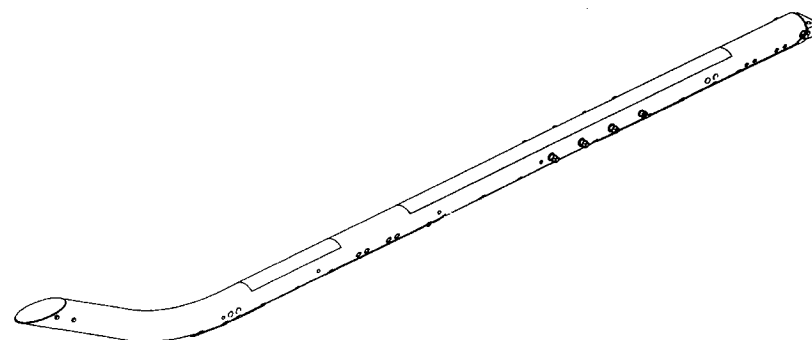
**NOTE:** Date & initial all entries



86330



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-09-22/14

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	SA	<b>D2750</b>	SHEET 3 OF 11
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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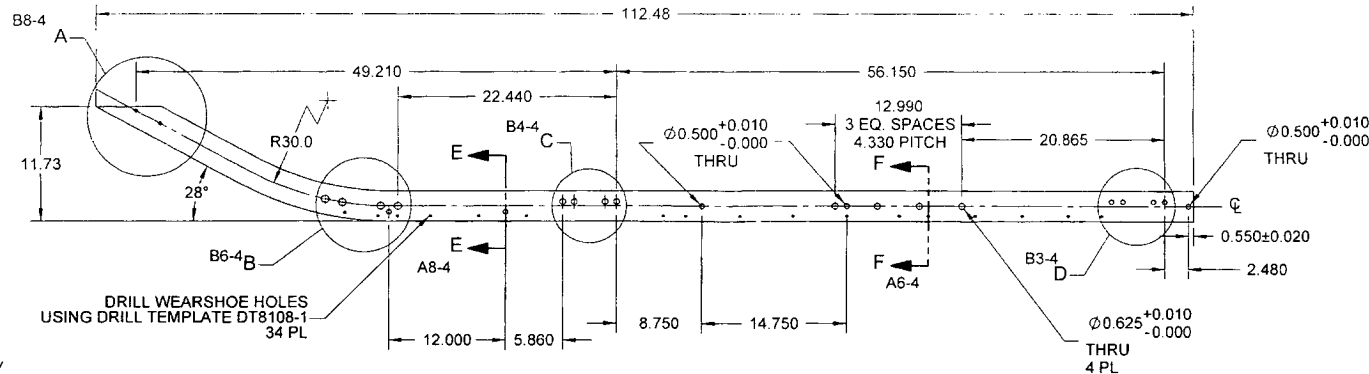
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

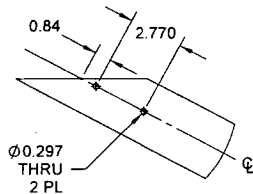
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

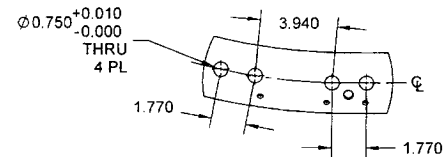
**NOTE:** Date & initial all entries



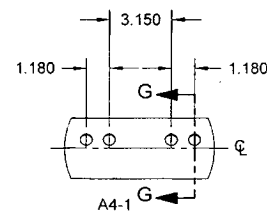
**D2750-1 LH SKIDTUBE**



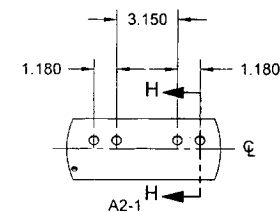
**DETAIL A**  
SCALE 2X



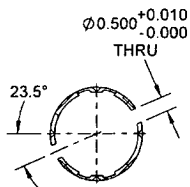
**DETAIL B**  
SCALE 2X



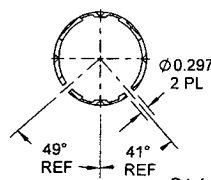
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SCALE 2X



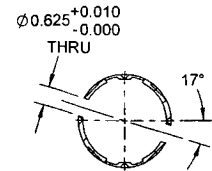
**DETAIL D**  
SCALE 2X



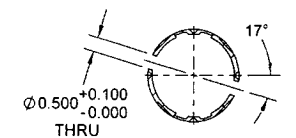
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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DESIGN	100	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	100	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

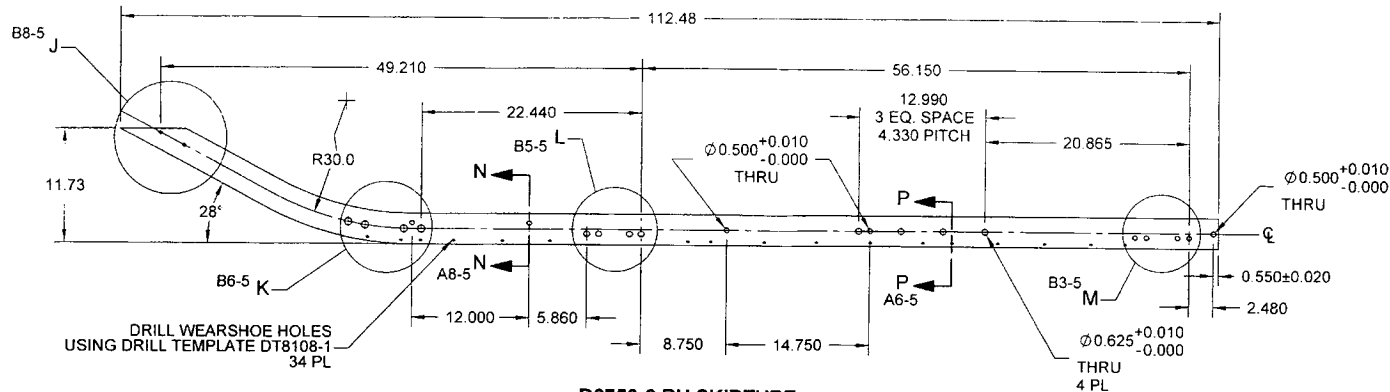
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

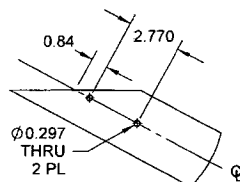
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

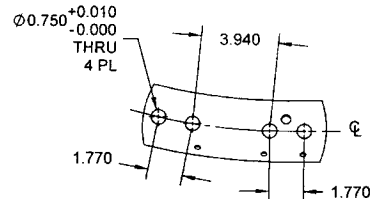
86330



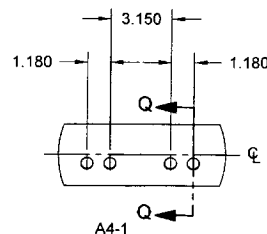
**D2750-2 RH SKIDTUBE**



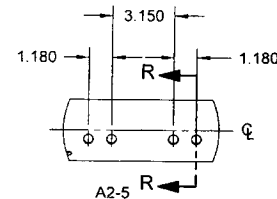
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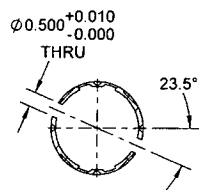
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SCALE 2X



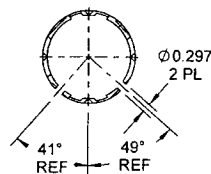
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SCALE 2X



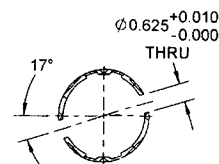
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SCALE 2X



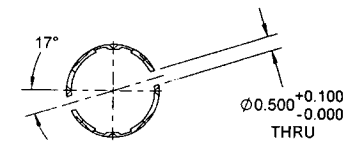
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
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DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

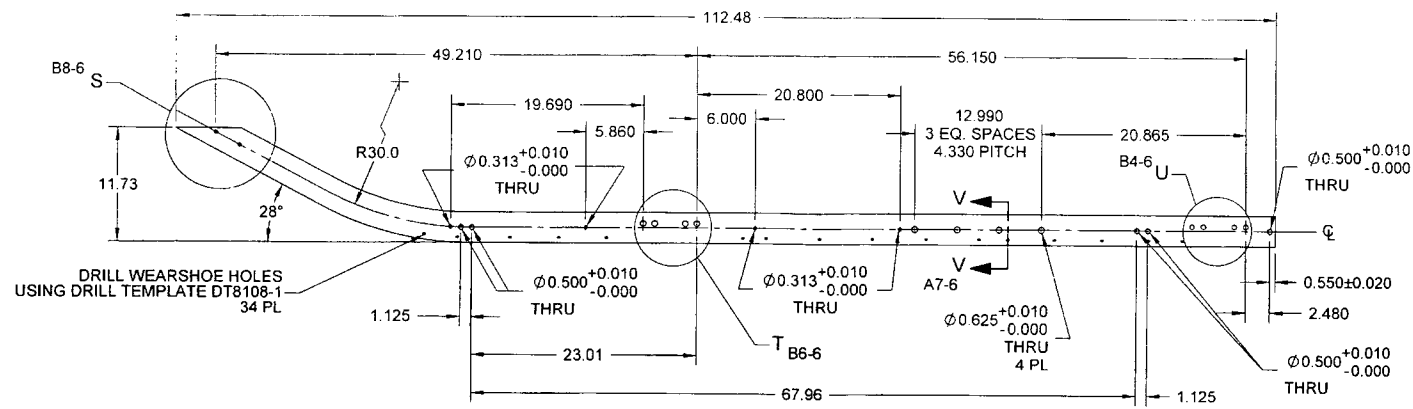
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

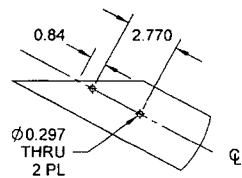
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

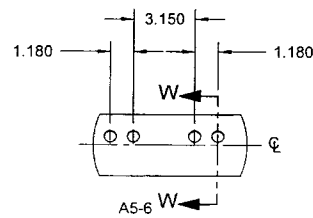
86330



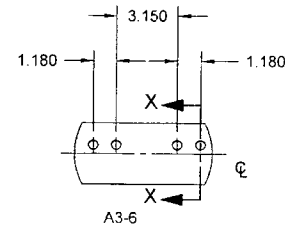
**D2750-3 LH SKIDTUBE**



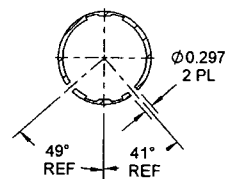
**DETAIL S**  
SCALE 2X  
D8-6



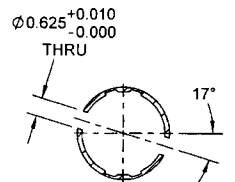
**DETAIL T**  
SCALE 2X  
C5-6



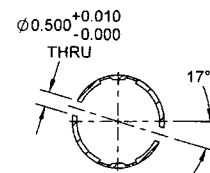
**DETAIL U**  
SCALE 2X  
D3-6



**SECTION V-V**  
SCALE 3X, 17 PL  
C4-6



**SECTION W-W**  
SCALE 3X, 4 PL  
B6-6



**SECTION X-X**  
SCALE 3X, 4 PL  
B4-6

**RELEASED**  
08 JAN 22 1988

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		SHEET 6 OF 11	
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

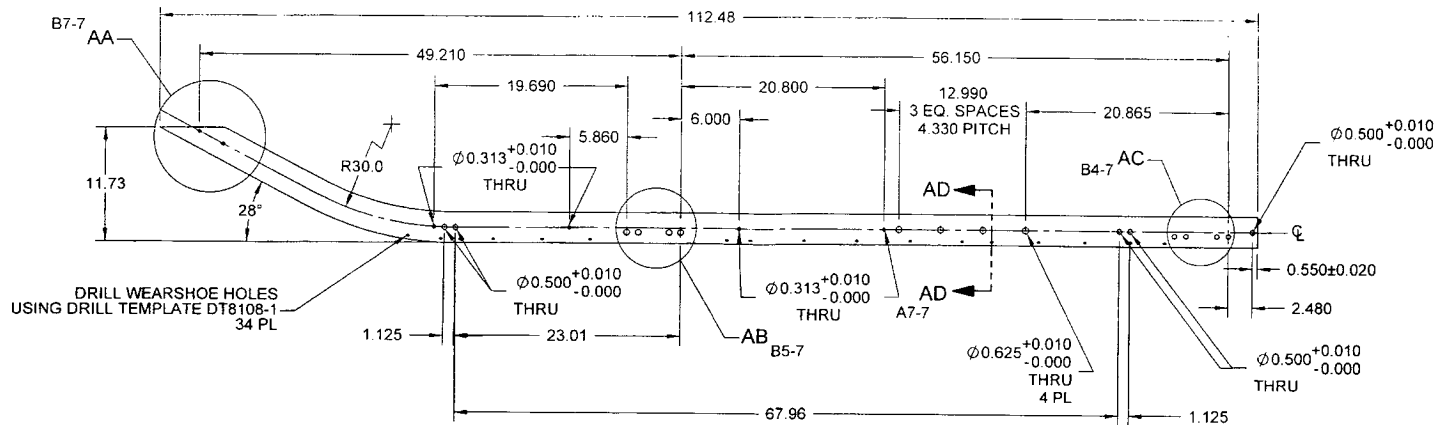
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

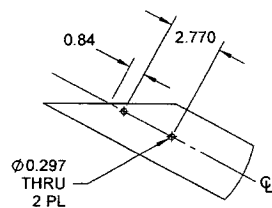
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

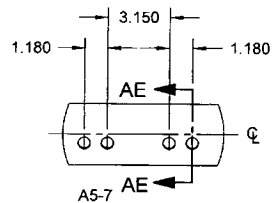




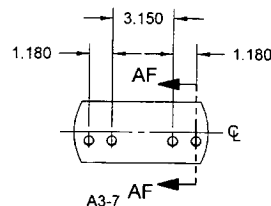
**D2750-4 RH SKIDTUBE**



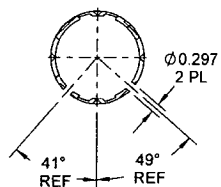
**DETAIL AA**  
SCALE 2X



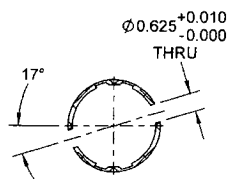
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SCALE 2X



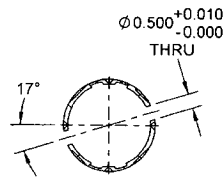
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**  
08-04-2010

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

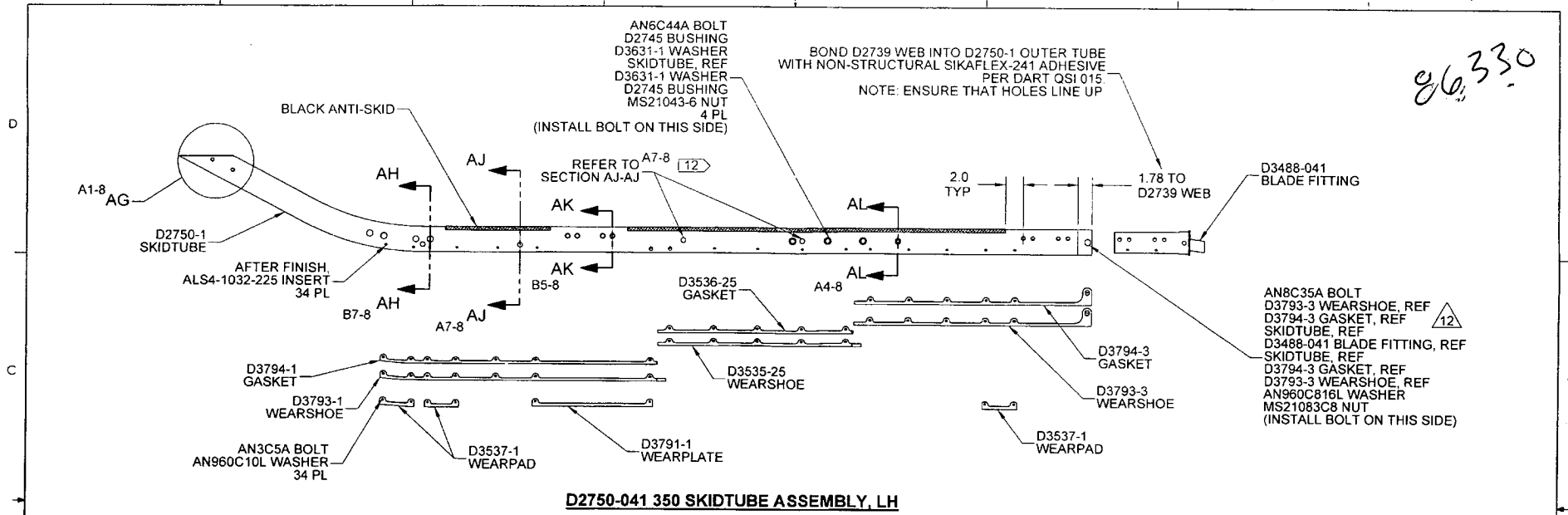
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

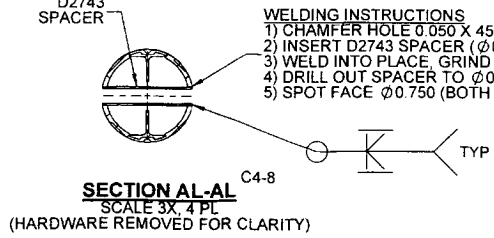
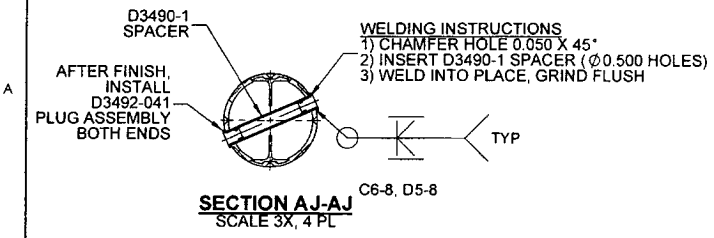
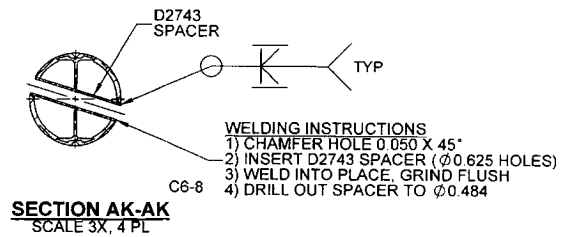
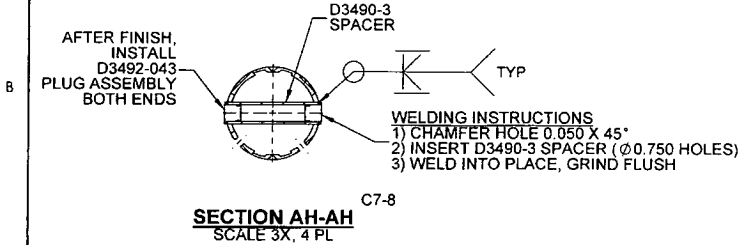
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86330



**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



**DETAIL AG**  
SCALE 2X  
**RELEASED**

DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PA	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		DRAWING NO. D2750
DATE	08.07.16	TITLE 350 SKIDTUBE ASSEMBLY
		REV. F SHEET 8 OF 11
		SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

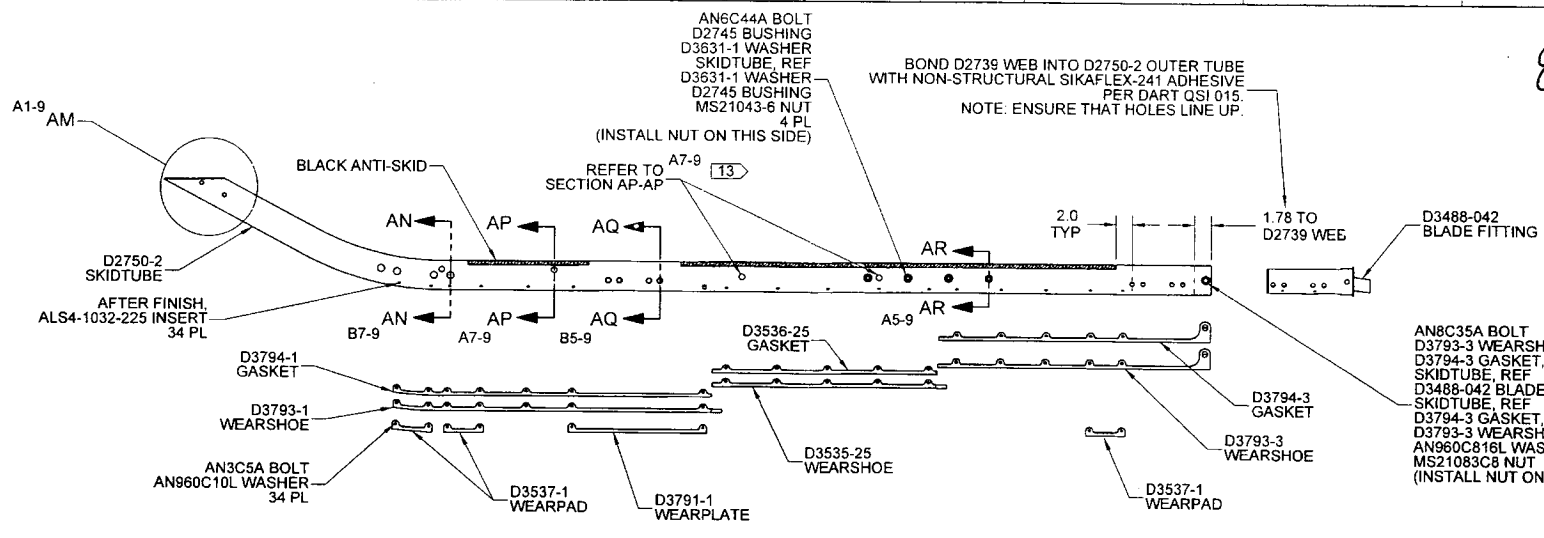
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

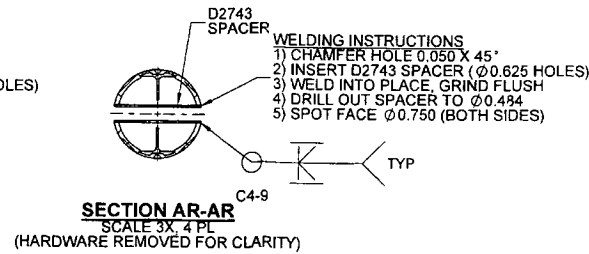
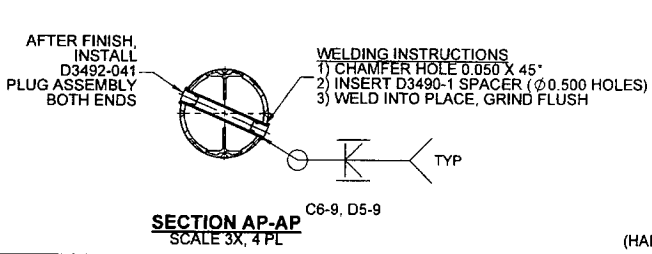
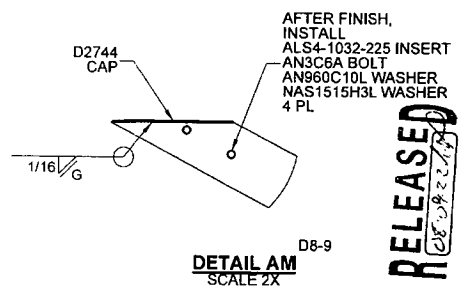
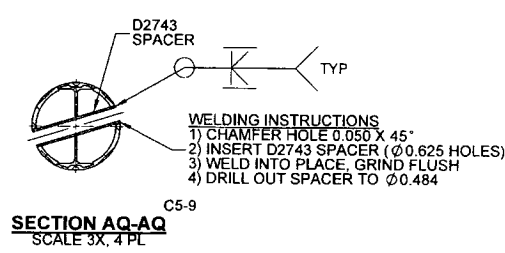
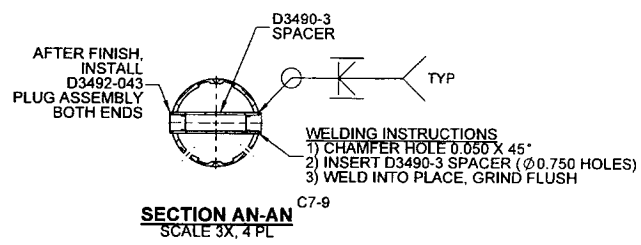
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86330



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
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08-09-2016

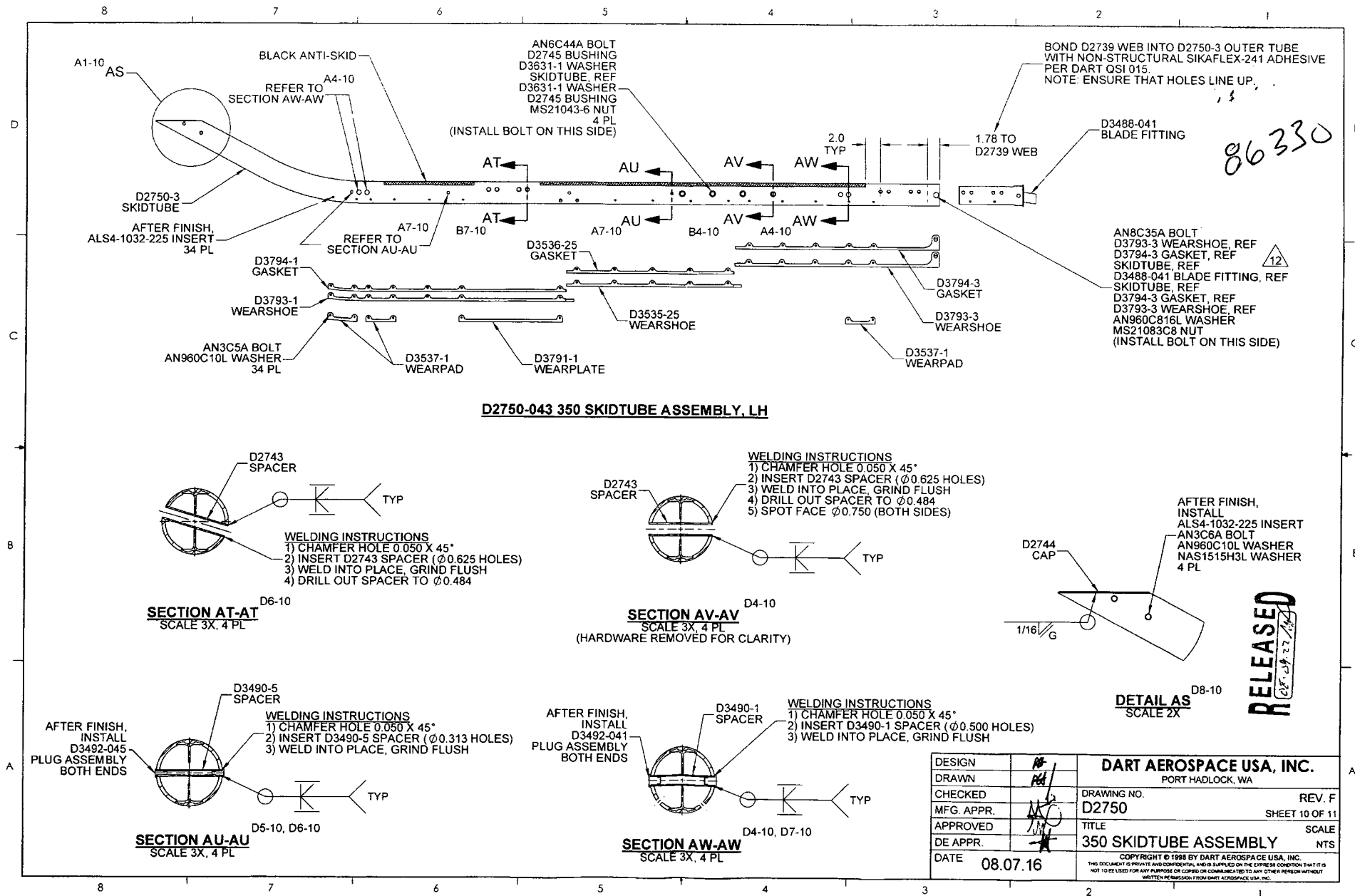
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	86330	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	86330	PORT HADLOCK, WA	
CHECKED	86330	DRAWING NO.	REV. F
MFG. APPR.	86330	D2750	SHEET 10 OF 11
APPROVED	86330	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

C

B

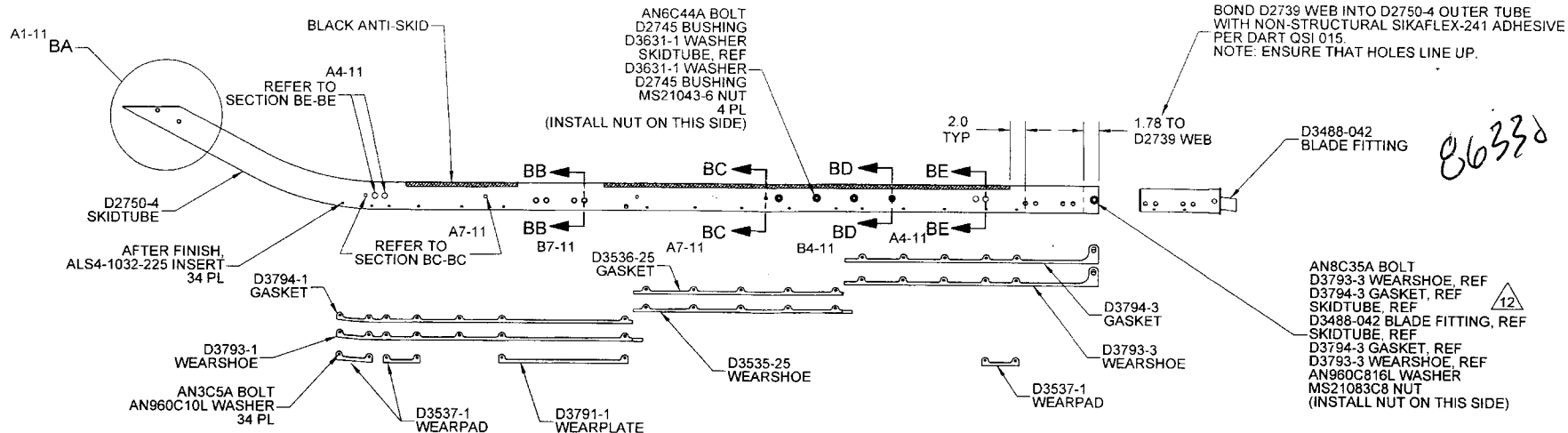
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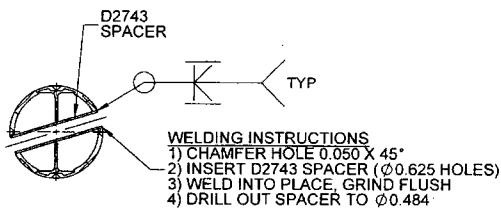
C

B

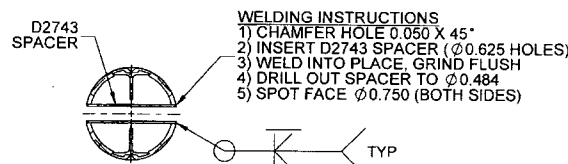
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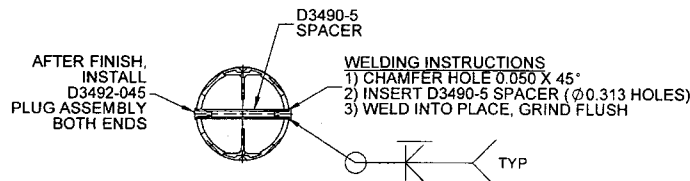
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



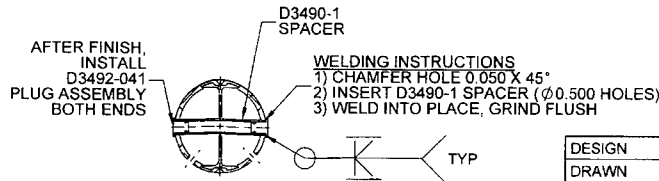
**SECTION BB-BB**  
SCALE 3X, 4 PL



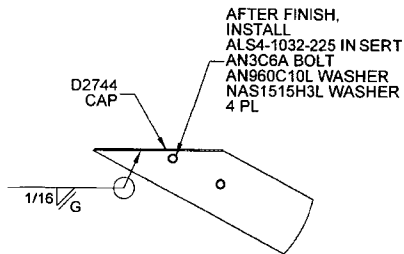
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	HA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries